

Date: Friday, 12/12/2008 9:14:32 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : NUT PLATE ASSEMBLY
<b>Job Number</b> : 44038	
<b>Estimate Number</b> : 11054	
<b>P.O. Number</b> :	<b>Part Number</b> : D2873045
<b>This Issue</b> : 12/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2873 REVA
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 43409	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 19/12/2008 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.12.12</u>	
<b>Comment</b> : Est A05.09.13 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00
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**Comment:** Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s)  
 6061T6 BAR  
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)  
 (M6061T6B0.375x01.000)  
 Identify for D2873-5  
 Batch: M110001

J.L 08/12/14

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks: 1.000" x 0.375" x 2.700" long

J.L 08/12/14

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA and Dwg D2873  
 Identify as D2873-5 Dwg Rev A Folio Rev AA

J.L 08/12/14

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/12/14

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Part Number: D2873045

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08/12/14 (20)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2- C'sink as per Dwg D2873

CP 08/12/15 (20)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15 (20) counter

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/15

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

M-L 08/12/15 (20X)

10.0 MS20426AD46 Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

4

MS20426AD4-6

Rivet

M105144

CP 08/12/15

11.0 MS21075L5 Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

2

MS21075L5

Nut Plate

M18136

CP 08/12/15

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Job Number: 44038

Part Number: D2873045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

*ep 08/12/15 (20)*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counters*  
*8 08/12/15 (+20)*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

*ml 09 02 12*

*(20)*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/02/13*

Job Completion



*mf 09-02-12*

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 44038
<b>Description:</b> Radius Block		<b>Part Number:</b> D2873-5
<b>Inspection Dwg:</b> D2873	<b>Rev:</b> A	<b>Page 1 of 1</b>

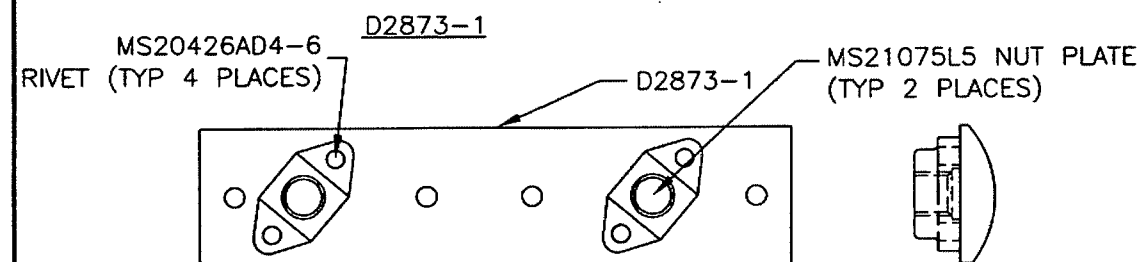
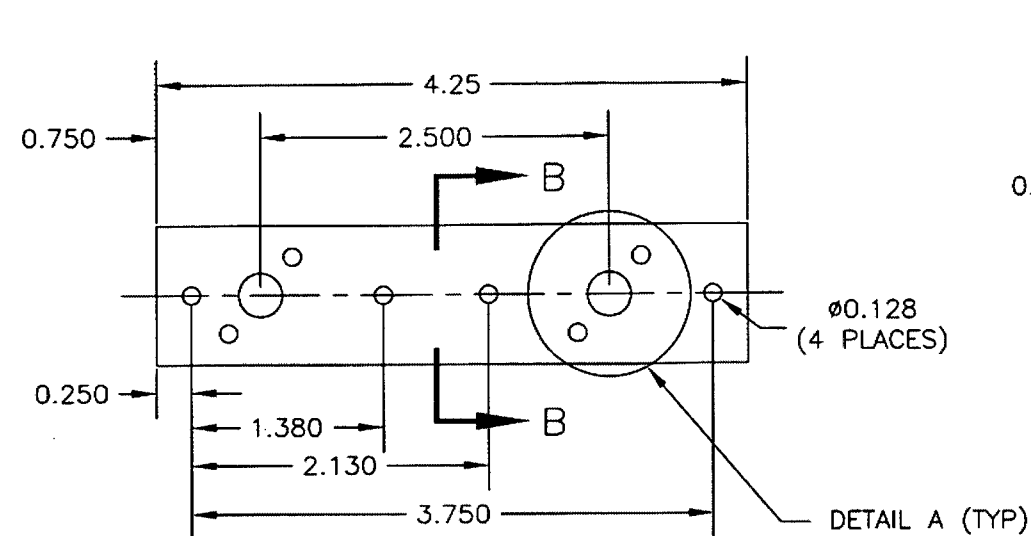
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

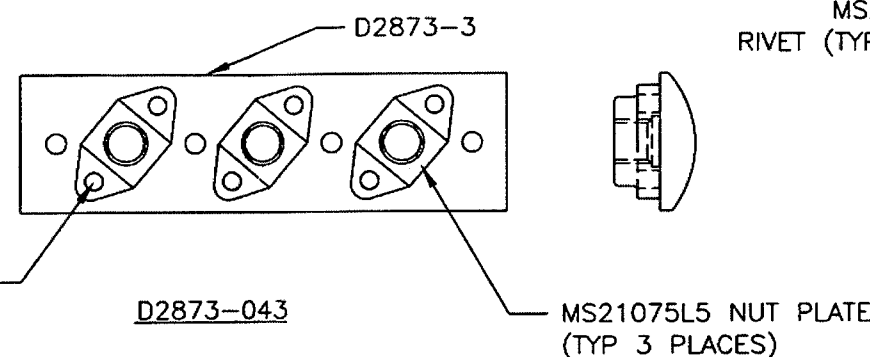
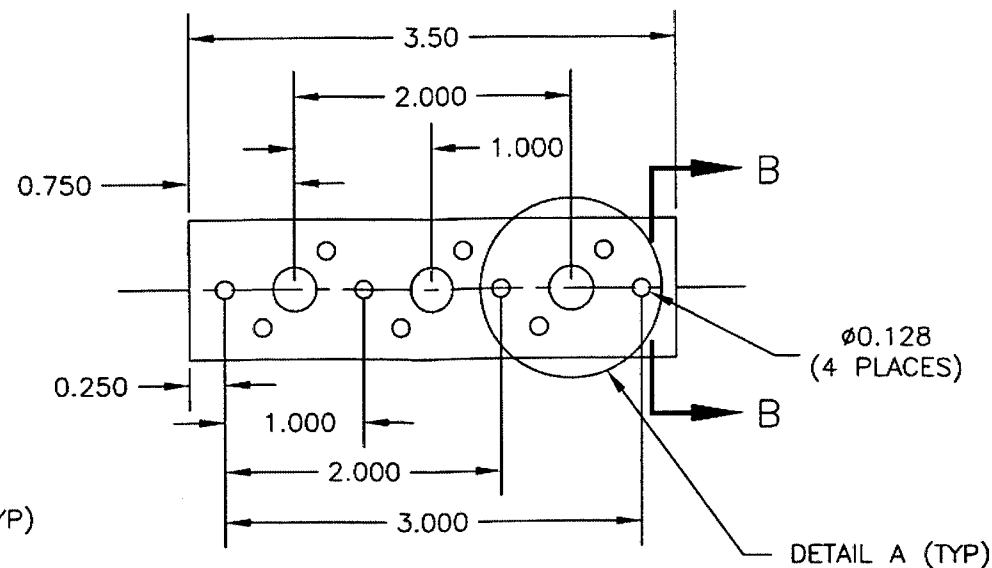
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.501	✓			
1.000	+/-0.010	1.000	✓			
0.750	+/-0.010	.747	✓			
0.250	+/-0.010	.248	✓			
1.000	+/-0.010	.999	✓			
2.000	+/-0.010	2.000	✓			
Ø0.128	+0.005/-0.001	.130	✓			
0.359	+/-0.010	.358	✓			
Ø0.316	+0.006/-0.001	.318	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.247	✓			
0.061	+/-0.010	.063	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .122	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/12/14	<b>Date:</b> 08/12/14	<b>Date:</b>	N/A

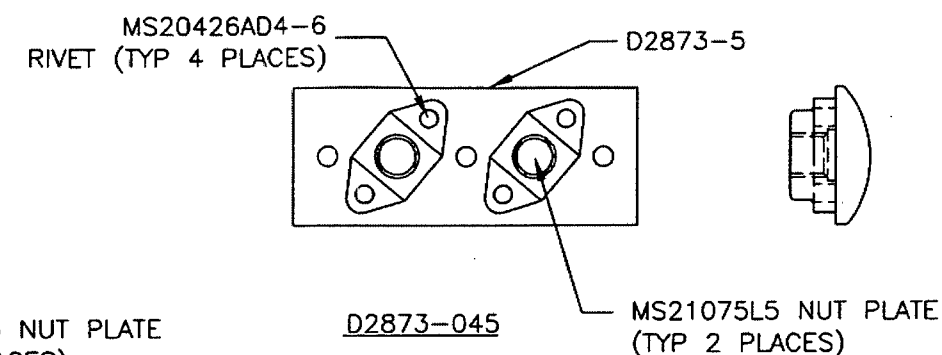
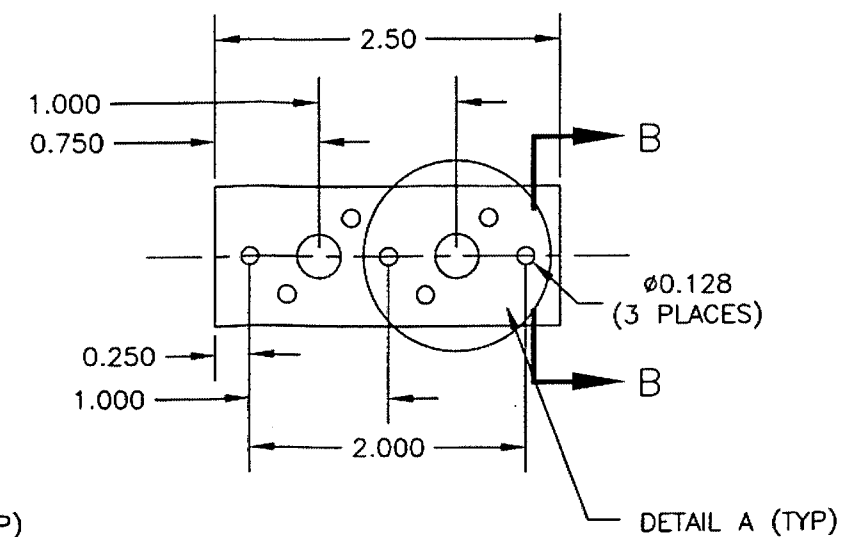
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	



D2873-041



D2873-043



D2873-045

**D2873-1/-3/-5 RADIUS BLOCK**

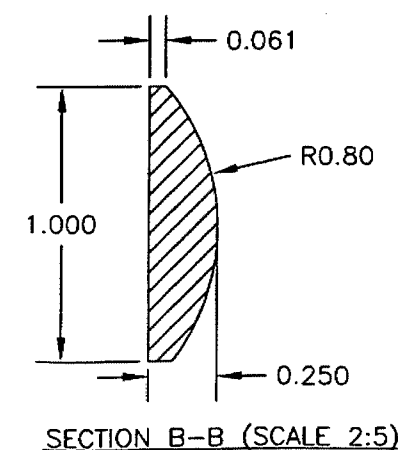
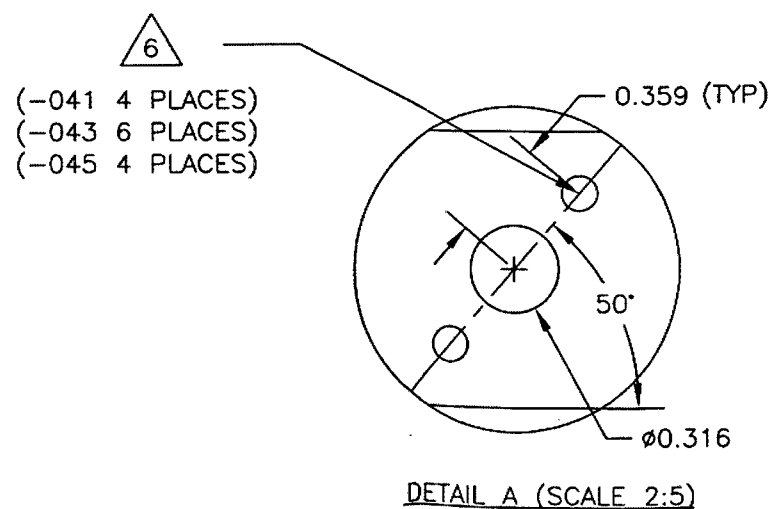
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6)  $\phi 0.128$  PILOT + C'BORE CURVED SIDE  $\phi 0.230 \times 0.125$  DEEP + C'SINK CURVED SIDE  $\phi 0.225 \times 100^\circ$

**D2873-041/-043/-045 NUT PLATE ASSEMBLY**

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

**D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SHOP COPY RETURN TO ENGINEERING